

Date: Wednesday, 02/04/2008 11:27:14 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HELI ACCESS HANDLE WELDMENT ASS'Y, LH
Job Number	: 38292		
Estimate Number	: 10946		
P.O. Number	:	Part Number	: D2480011
This Issue	: 02/04/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2480 REV A1
First Issue	: / /	Project Number	: N/A
Previous Run	: 38024	Drawing Revision	: A1
	Type : LARGE FAB ASSY	Material	:
Written By	:	Due Date	: 09/04/2008
Checked & Approved By	: <u>JD 08.04.02</u>	Qty:	5
Comment	: Est. B1 03.01.09 added Powder Coat	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2478	Lower Arm
-----	-------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
 Lower Arm

Pick:

Qty	Part number	Description	Batch
1	D2478	Heli Access Handle	B 38146 ✓ 08-04-08 SP

2.0	D2479	Upper Arm
-----	-------	-----------

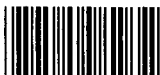


Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
 Upper Arm

Pick:

Qty	Part number	Description	Batch
1	D2479	Heli Access Handle	B 38228 ✓ 08-04-08 SP

3.0	D2481	Lower Mount Plate
-----	-------	-------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)
 Lower Mount Plate

Pick:

Qty	Part number	Description	Batch
2	D2481	Mounting Plate	B 38147 ✓ 08-04-08 SP

4.0	D2482	Upper Mount Plate
-----	-------	-------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
 Upper Mount Plate

Pick:

Qty	Part number	Description	Batch
1	D2482	Mounting Plate	B 14648 ✓ → 2x B 23504 → 3x 08-04-08 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 02/04/2008 11:27:14 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS HANDLE WELDMENT ASS'Y, LH

Job Number: 38292

Part Number: D2480011

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



M106762



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Template DT 8333 (DT 2480 CJ)

SP 08-04-07

(5X)

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-04-07 (5)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SP 08/04/07 (SLH)

8.0

POWDER COATING

POWDER COATING



M 107550



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

BR 08-04-07

(5) LH

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SLH
M. 08/04/07

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPP 38275

PC 8/4/8 (5)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/09

Job Completion



MF 08-04-08

N

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

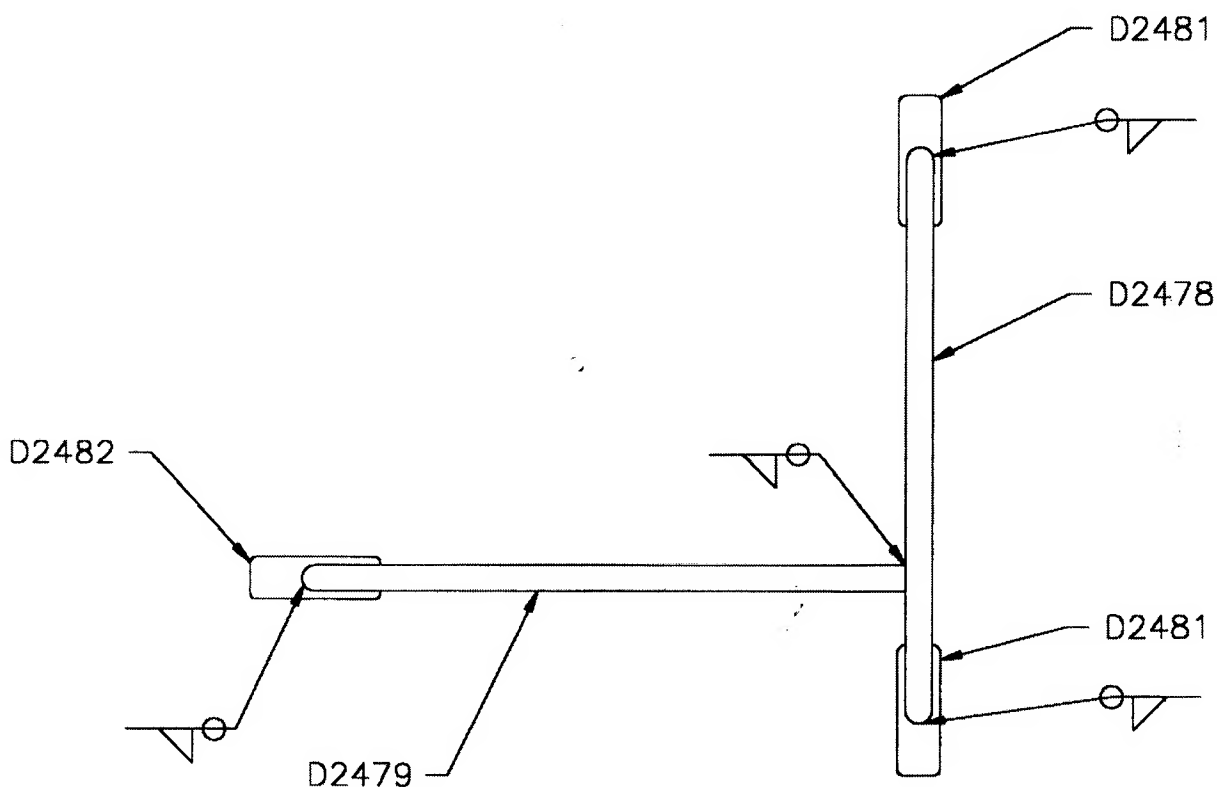
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	MIKE M	DRAWING NO.	REV. A
CHECKED BW	APPROVED BW	D2480	SHEET 1 OF 1
DATE	TITLE	SCALE	
96:05:14	HANDLE WELDMENT ASSEMBLY	6:1	
A1 11/05.06.23		ADDED POWDER COAT	

RELEASED
96/10/02 DS



D2480-011 LH SHOWN
D2480-012 RH OPPOSITE

NOTES:

- 1) WELD PER TEMPLATE DT 2480 WG PER QSI 004
2) POWDER COAT WHITE GLOSS (REF: 4.3.5.2) AS PER QSI 005

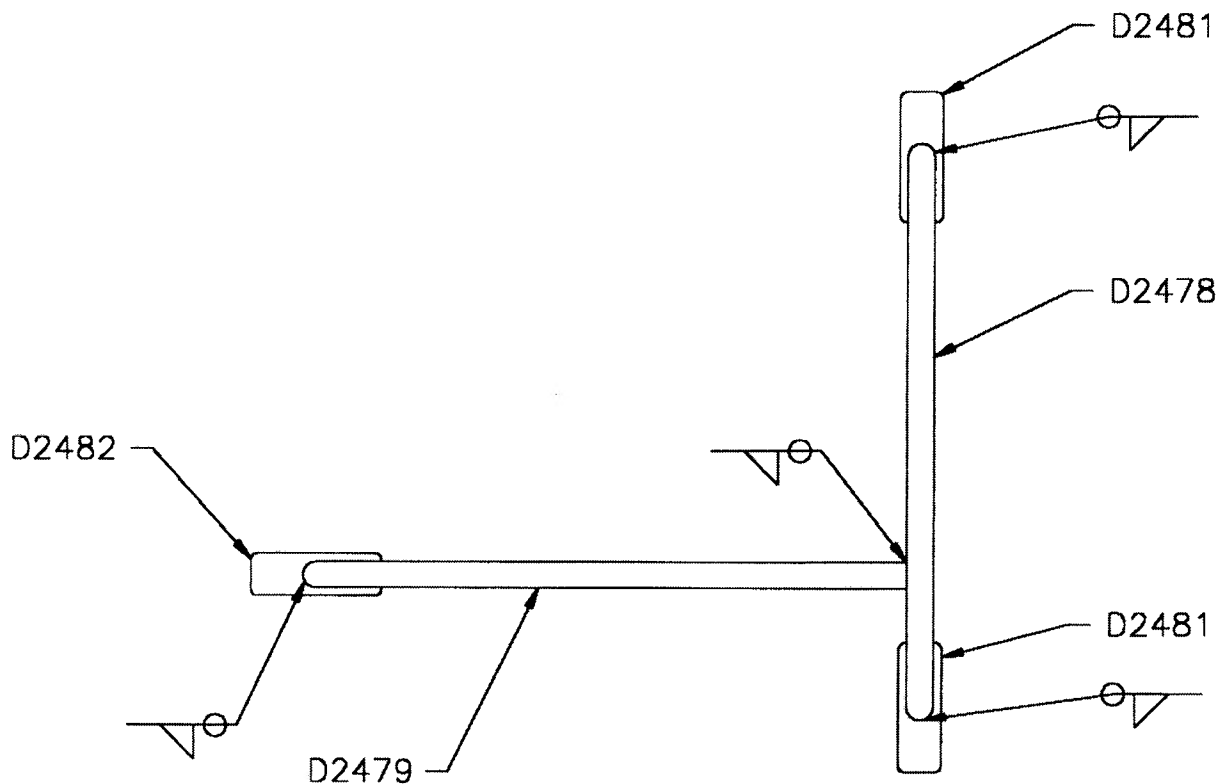
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B WILLIAMS	MIKE M		
CHECKED	APPROVED	DRAWING NO.	REV. A
BW	BW	D2480	SHEET 1 OF 1
DATE		TITLE	SCALE
96:05:14		HANDLE WELDMENT ASSEMBLY	6:1
A1 05.06.23		ADDED POWDER COAT	

RELEASED
16/10/02 DS



D2480-011 LH SHOWN
D2480-012 RH OPPOSITE

NOTES:

- 1) WELD PER TEMPLATE DT 2480 WG PER QSI 004
2) POWDER COAT WHITE GLOSS (REF: 4.3.5.2) AS PER QSI 005

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